

Date: Friday, 29/05/2009 3:46:01 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 48298B		
Estimate Number	: 10207		
P.O. Number	:	Part Number	: D2989043
This Issue	: 29/05/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2989 REVD
First Issue	: 29/05/2009	Project Number	: N/A
Previous Run	: 47941B	Drawing Revision	: D
		Material	:
Written By	:	Due Date	: 08/06/2009
Checked & Approved By	: <u>JUD 09.05.29</u>	Qty:	1 Um: Each
Comment	: Est Rev:I Removed D2989-041 05-11-03 JLM Est Rev:J 08-08-29 revC as per dwg DD verified by:EC Est Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC Est Rev:L 08-12-02 revD as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
✓ 1.0	D29893	Rib
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: <u>B48328</u> PD 09.06.10		
✓ 2.0	D29894	Rib
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: <u>B432 B48329</u> PD 09.06.10		
✓ 3.0	D29895	Rib
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Rib batch: <u>B45606</u> PD 09.06.10		
✓ 4.0	D22211	Rib
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: <u>B48101</u> PD 09.06.10		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 29/05/2009 3:46:01 PM
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Drawing Name: BASKET LID ASSEMBLY

Job Number: 48298B

Part Number: D2989043

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 5.0

D31821

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Hinge

batch: B45504

PD 09.06.10

✓ 6.0

D34423

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Shim

batch: B45607-11

B47265

PD 09.06.10

✓ 7.0

D3827041

Rib Assembly (Inboard)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib Assembly (Inboard)

batch: B48100

PD 09.06.10

✓ 8.0

D38325

Mesh (Lid)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mesh (Lid)

batch: B46307

PD 09.06.10

✓ 9.0

D38335

Mesh (Lid End)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mesh (Lid End)

batch: B44767

PD 09.06.10

✓ 10.0

D3838041

Rib Assembly (Basket Lid, LH)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib Assembly (Basket Lid, LH)

batch: B48333

PD 09.06.10

✓ 11.0

D3838042

Rib Assembly (Basket Lid, RH)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib Assembly (Basket Lid, RH)

batch: B48334

PD 09.06.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 29/05/2009 3:46:01 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 48298B

Part Number: D2989043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- assemble all ribs in DT9446 jig, weld as per dwg D2989
 - 2- tack weld mesh on basket as per dwg D2989 using DT9446 jig
 - 3- to locate hinges and shims use D2989-041, weld as per dwg D2989
- A/R ER316 S.S. Rod Batch: M108160

24/09/06/10 / D 09.06.10

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09.06.15

14.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5 or 6/15

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Plug holes prior to powder coating

2- Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT

START TIME: 10:00am

OVEN TEMPERATURE: 400°F

FINISH TIME: 10:30am

***** 2nd coat if necessary*****

2ND COAT:

START TIME: 11:00am

OVEN TEMPERATURE: 400°F

FINISH TIME: 11:30am

24/09-06-15

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

09-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 48298B

Part Number: D2989043

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/18 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

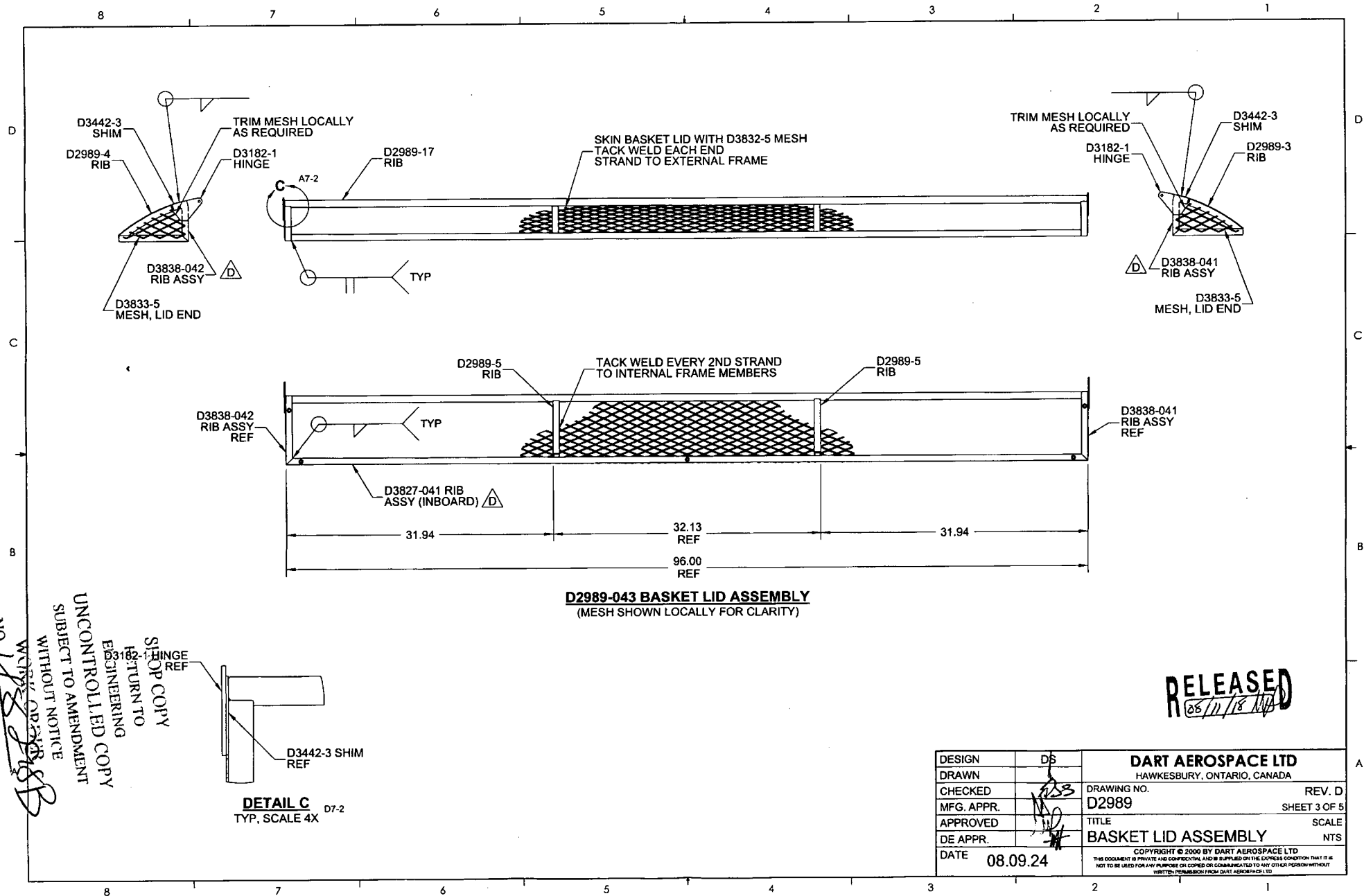
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

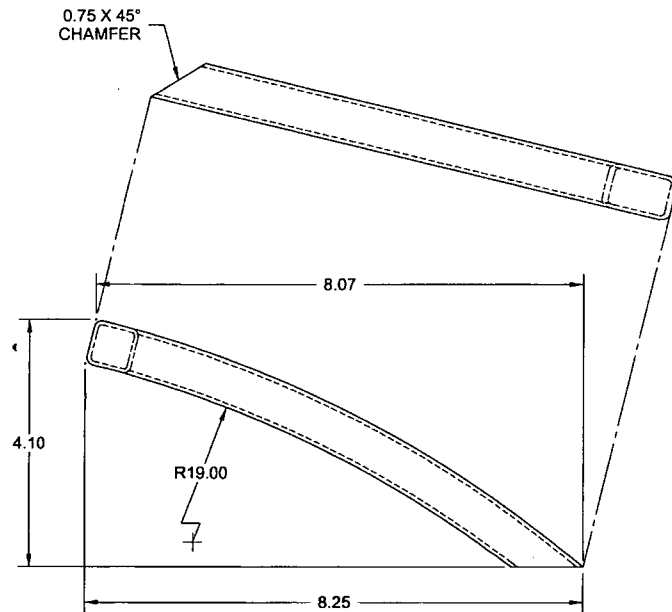
RELEASED
08/11/18

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3836-041 REPLACES D2989-1/-7; D3836-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D2989	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	08.09.24		

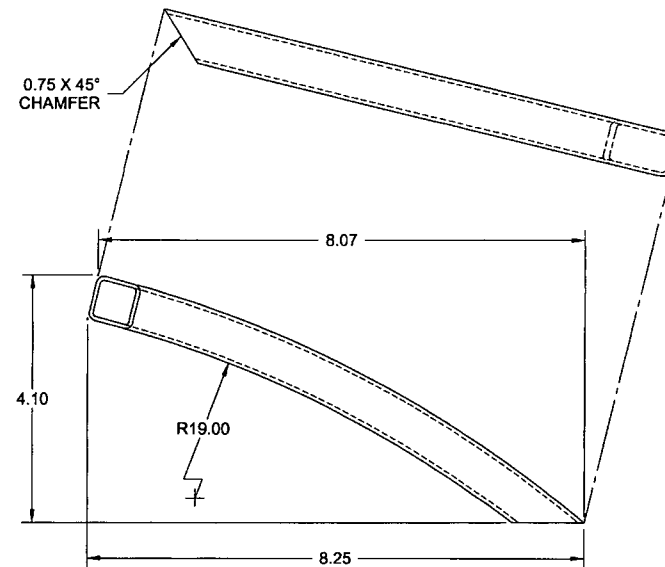
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WORK ORDER NO. 1820610

- 1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
8) WELD PER DART QSI 004

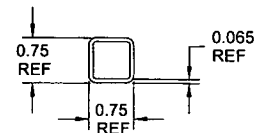




D2989-3 RIB





D2989-4 RIB



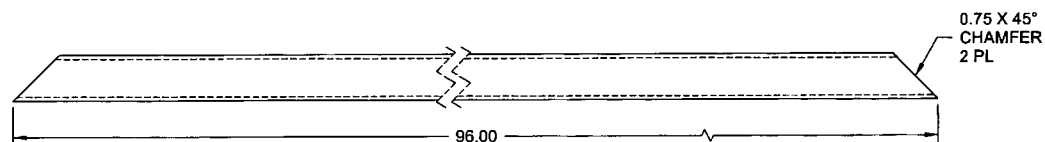
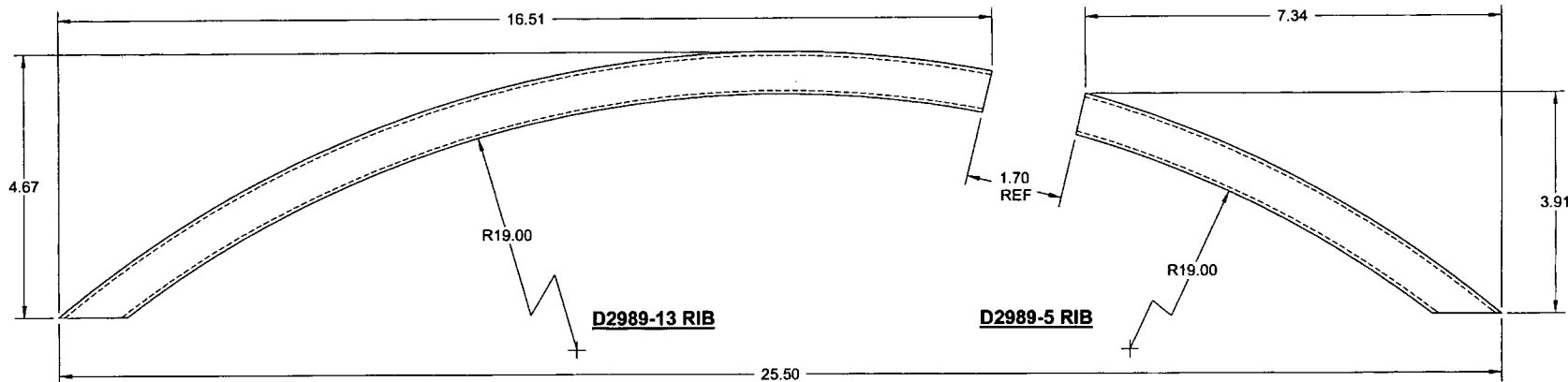
**TYPICAL SECTION
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

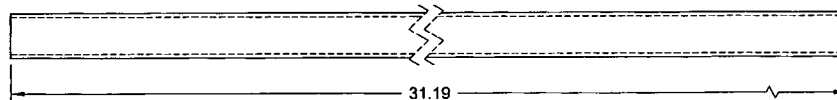
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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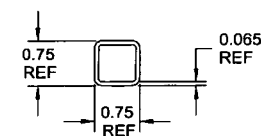
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D2989-17 RIB



D2989-19 RIB



**TYPICAL SECTION
VIEW**

RELEASED
08/11/18

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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